40

Date: Wednesday, 9/19/2007 3:49:55 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: SKID TUBE ASSEMBLY
Job Number	: 34710		
Estimate Number	: 10023		
P.O. Number	: N/A	**Part Number**	: D205634041
This Issue	: 9/19/2007 **S.O. No.** : N/A	**Drawing Number**	: D2580 REV D
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : LANDING GEAR	**Drawing Revision**	: D
Previous Run	: 34709	**Material**	: N/A
Written By	:	**Due Date**	: 10/5/2007 **Qty:** 1 **Um:** Each
Checked & Approved By	: KJ 07.09.19		

Comment : Est Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
Est Rev. O 06.02.28 Added paperwork EC
Est Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy D205-634 bluefile & type labels per PPP D205-634 CHG002 KJ 07.09.19 (1)

2.0	D25001190	Ext'n -'I' Beam Tube 4"

Comment: Qty.: 1.0400 Each(s)/Unit Total : 1.0400 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2500-1-190	Skid Tube Extrusion	B29602

R 7-9-20

3.0	D2596	205 Web

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2596	205 Web	33836

SL 7-9-20

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2580 if necessaryDeburr ends

R 7-9-20

3-Acid etch and Alodine tube per QSI 005 4.1 SL 7-9-20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Job Number: 34710 **Part Number:** D205634041

Job Number:

Seq. #: **Machine Or Operation:** **Description :**

5.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION SL 07/09/21

6.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes using drill jig DT 8149(Do not use cutting fluid)

2-Open holes to 0.500" as per Dwg D2580without cutting fluid

3-Countersink holes as per Dwg D2580without cutting fluid

4-Deburr and blow out all chips from inside of tube

5-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

SL 7-9-21

Pick:

Qty	Part Number	Description	Batch
A/R		Sikaflex-291	105488

Sikaflex expire date: 8-7-1

Start Time: 9:20 Date: 7-9-21

Fin Time: 10:15 Date: 7-10-1

7.0 BENDING BENDING MACHINE

Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580 EL 7-10-1

8.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Deburr ends

2-Prepare tube for welding, remove alodine as required. SL 7-10-9

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

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Job Number: 34710 **Part Number:** D205634041

Job Number:

Seq. #:	Machine Or Operation:	Description :
9.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP BE 07/10/12

10.0	D25763	Step (Machining Detail)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2576-3	Step	B-33464

BE 07/10/12

11.0	D2579	Crossbolt Spacer

Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
20	D2579	Spacers	B34347

BE 07/10/12

12.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

2-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R Aluminum Rod m105058 BE 07/10/12

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004.
For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R Aluminum Rod m105058 BE 07/10/12

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending AWM 07-10-15

5-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web.Deburr

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes SL 07-10-22

7-Drill pilot holes for aft cap using DT 8215Open holes to 0.208". Deburr AWM 07-10-15

8-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr SL 7-10-22

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W/O:		WORK ORDER CHANGES						
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 34710 **Part Number:** D205634041

Job Number:

Seq. #:	Machine Or Operation:	Description :
13.0	QC9	VISUAL WELDING INSPECTION
	Comment: VISUAL WELDING INSPECTION	PD 07-10-23 (1)
14.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	07/10/23
15.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 (IX)
	Comment: HAND FINISHING RESOURCE #1 Pressure wash as per QSI 005	07/10/25
16.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	M105068 BR 07-10-29
17.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION (1)
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	07 10 29
18.0	D2855	Cap
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Cap Batch: B29608	
19.0	AN35A	Bolt
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Bolt Batch: M100188	
20.0	AN960JD10L	Washer
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Washer Batch: M104885	07-10-30 (1)

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W/O:		WORK ORDER CHANGES						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SKID TUBE ASSEMBLY

Job Number: 34710 **Part Number:** D205634041

Job Number:

Seq. #:	Machine Or Operation:	Description :
21.0	ALS71032130	Insert

Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)
Insert
Batch: 105729 ml 07 10 29

22.0	AN3C4A	BOLT

Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)
BOLT
Batch: 105810 ml 07 10 29

23.0	AN960C10L	washer

Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)
washer 105906 ml 07 10 29

24.0	D356613	GASKET

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GASKET
Batch: 132744 ml 07 10 29

25.0	D35665	GASKET

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GASKET
Batch: 34354 ml 07 10 29

26.0	D35661	GASKET

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
GASKET
Batch: 34847 ml 07 10 29

27.0	D356413	WEARSHOE

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: 33867 ml 07 10 29

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W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

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NOTE: Date & initial all entries

Date: Wednesday, 9/19/2007 3:49:55 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SKID.TUBE ASSEMBLY

Job Number: 34710 **Part Number:** D205634041

Job Number:

Seq. #:	Machine Or Operation:	Description :
28.0	D356411	WEARSHOE

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: 34352 ml 07 10 29

29.0	D35649	WEARSHOE

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: 34807 ml 07 10 29

30.0	D35645	WEARSHOE

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: 34806 ml 07 10 29

31.0	D25943	O-Ring

Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
O-Ring
Batch: 27168 ml 07 10 29

32.0	D25941	Plug

Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
Plug
Batch: 34790 ml 07 10 29

33.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R Sikaflex-291 M105585
Sikaflex expire date: 08/07

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

ml 07 10 29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** D **Date:** 07/11/02

QA: N/C Closed: _____ **Date:** _____

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DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SKID TUBE ASSEMBLY

Job Number: 34710 **Part Number:** D205634041

Job Number:

Seq. #	Machine Or Operation:	Description :
		4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive A/R Sikaflex-291 M105585 JD 07-10-30 (1) Sikaflex expire date: 08-07 5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch: (1x) M106030 07/10/30
34.0	QC5	INSPECT WORK TO CURRENT STEP 07/10/31
	Comment:	Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024
35.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment:	PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D205-634-041 Location: H 07/11/01 PPP Rev:
36.0	QC21	FINAL INSPECTION/W/O RELEASE (1)
	Comment:	FINAL INSPECTION/W/O RELEASE 07/11/01

Job Completion

07.11.02

34710

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**		**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS

A	96.09.16	NEW ISSUE
B	96.12.02	AS MANUFACTURED
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183

RELEASED
07 06 28

QTY -041	QTY -045	Part Number	Description
X		**D2580-041**	**SKIDTUBE ASSEMBLY**
	X	**D2580-045**	**SKIDTUBE ASSEMBLY**
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
2) ALL DIMENSIONS ARE IN INCHES
3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
6) WELDING TO BE DONE PER DART QSI 004.
7) FINISH:
   SEE NOTES ON
   PAGE 2 FOR D2580-041 AND
   PAGE 3 FOR D2580-045
8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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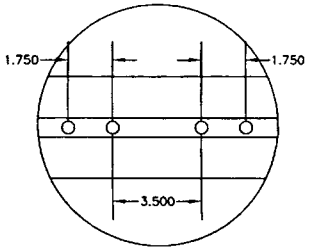
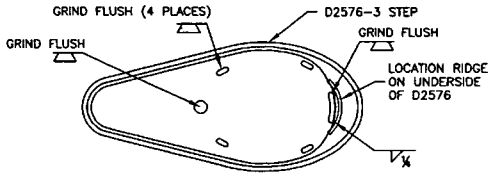
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34710

DETAIL A
SCALE 5:24

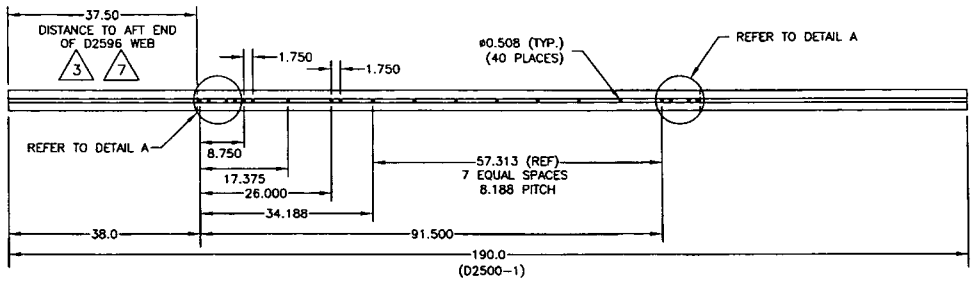


RELEASED
07.a 28

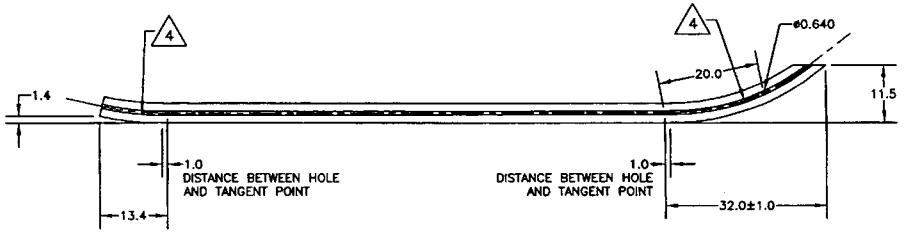
DETAIL B
SCALE 5:24



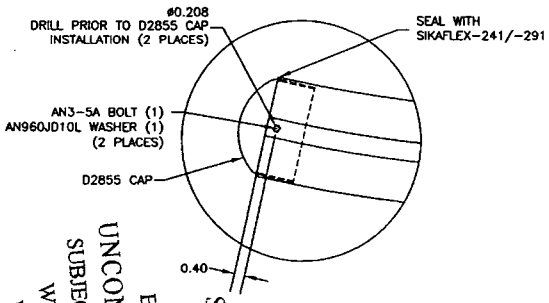
D2580-1 DRILLING DETAIL



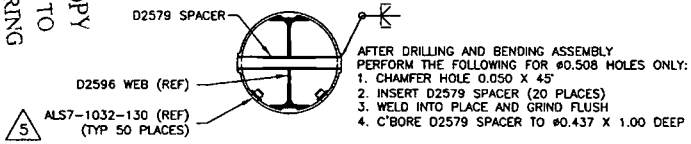
D2580-1 BENDING AND CUTTING DETAIL



DETAIL C
SCALE 5:24

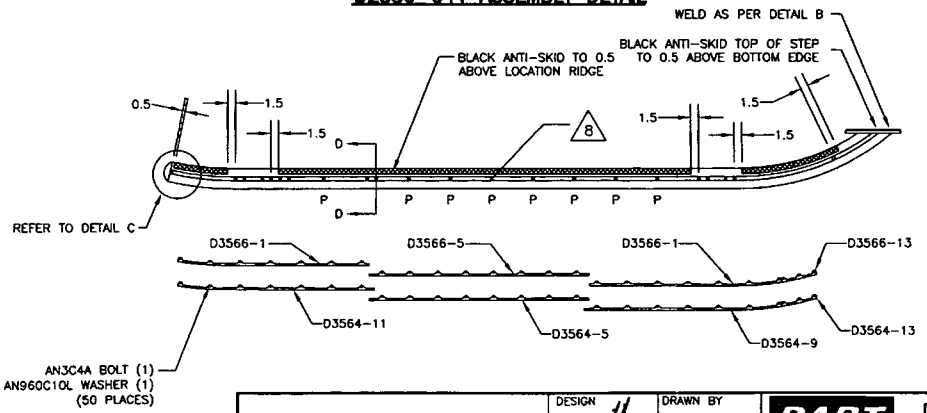


SECTION D-D
SCALE 5:24



AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO ø0.437 X 1.00 DEEP

D2580-041 ASSEMBLY DETAIL



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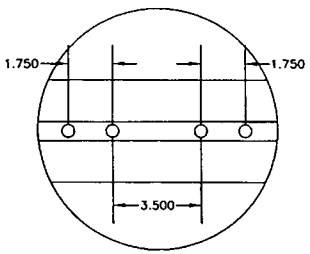
WORK ORDER NO. 3110

D2580-041 NOTES

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

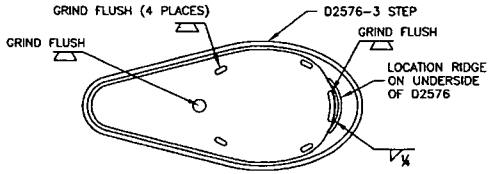
DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2580 REV. D
DATE 07.02.27		SHEET 2 OF 3
		TITLE 205 SKIDTUBE ASSEMBLY SCALE 1:24

DETAIL E
SCALE 5:24

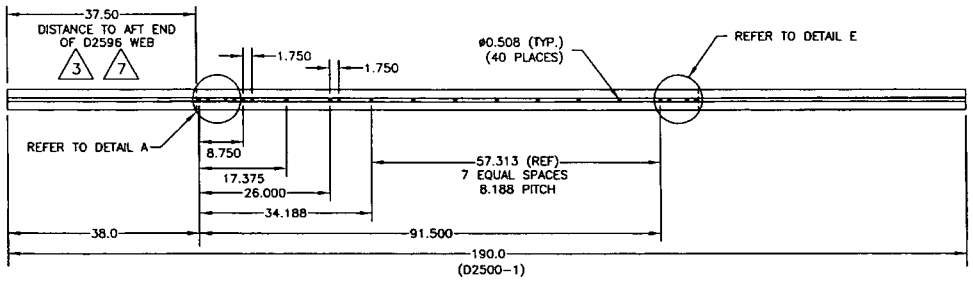


RELEASED
07 de 28

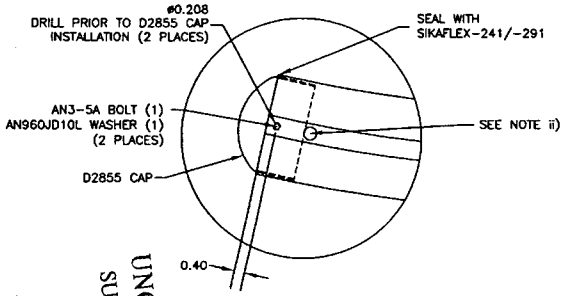
DETAIL F
SCALE 5:24



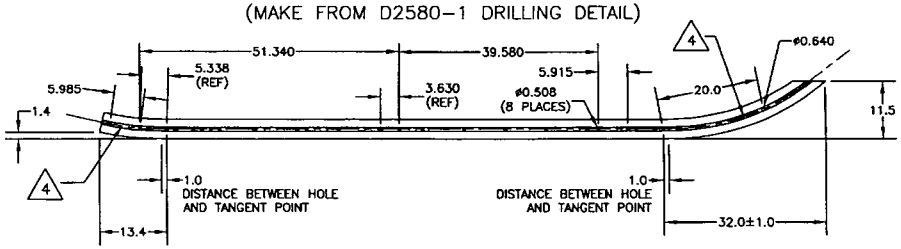
D2580-1 DRILLING DETAIL



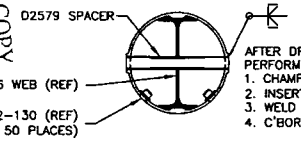
DETAIL G
SCALE 5:24



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)

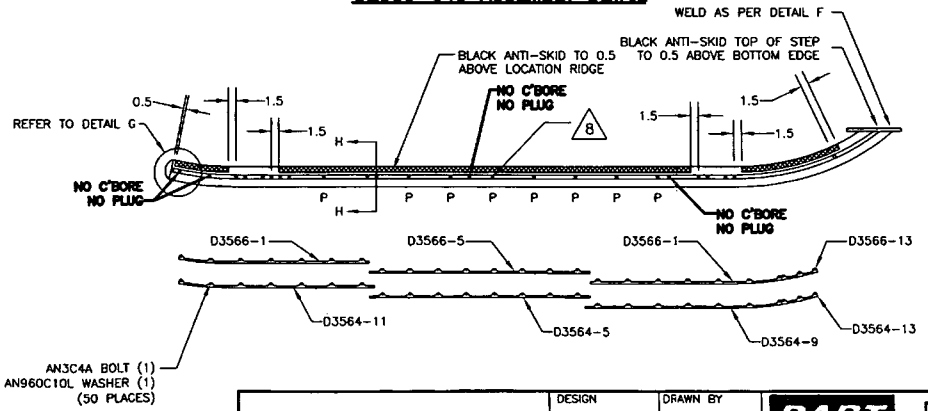


SECTION H-H
SCALE 5:24



AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO ø0.437 X 1.00 DEEP

D2580-045 ASSEMBLY DETAIL



C

D2580-045 NOTES

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
RH	RH		
CHECKED	APPROVED	DRAWING NO.	REV. D
		D2580	SHEET 3 OF 3
DATE		TITLE	SCALE
07.02.27		205 SKIDTUBE ASSEMBLY	1:24

NO. 129

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure tig
Part number and Job number 9D205 134 cu. / B243324

TEST WELDS REQUIRED

BASE METAL Aluminum
Penetration Complete [ ] Partial [✓]
Current AC [✓] DC [ ]

WELDING PROCESS tig
Single Weld [✓] Double Weld [ ]
Backing YES [ ] NO [✓]

	Position		Vertical Down [ ]	Up [ ]
Sheet Groove	1G [ ]	2G [ ]	3G [ ]	4G [ ]
Tube Groove	1G [ ]	2G [ ]	5G [ ]	6G [ ]
Sheet Fillet	1F [ ]	2F [ ]	3F [ ]	4F [ ]
Tube Fillet	1F [ ]	2F [ ]	4F [ ]	5F [ ]

Crossbolt Spacer Welded into ________________ Skidtube

TEST RESULTS

Visual	Pass [✓]	Fail [ ]
Penetration	Pass [✓]	Fail [ ]
Crossbolt Spacer	Pass [✓]	Fail [ ]

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 01-10-03 Qualifier [signature]